

Date: Thursday, 6/15/2006 1:41:54 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG  
 Job Number : 27563  
 Estimate Number : 10337  
 P.O. Number : N/A Part Number : D28073  
 This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D2807 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C  
 Previous Run : 27152 Material : N/A  
 Written By : See Comment Below Due Date : 7/10/2006 Qty: 160 Um: Each  
 Checked & Approved By : JA 06-15-16  
 Comment : Est A 05.00.02 New Issue KJ/JLM

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M303R0750

303 Round Bar .75"



Comment: Qty.: 0.1094 f(s)/Unit Total : 17.5056 f(s)  
 Material: 303 Round Bar Ø0.750"  
 (M303R0.750)

Batch: M101580  
AD 06/07/19

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE

Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C

2-Deburr

MS06/07/22183  
181

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1

Machine as per Folio FA528 and Dwg D2807 Dwg Rev: CFolio Rev: AA

2-Deburr

J.F. 06/07/31

183

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/07/31

183

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:41:54 PM  
User: Kim Johnston

## Process Sheet

✓ Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 27563

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G

06/07/31

183

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD

06/07/31

183

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/08/02

183

Job Completion



06/08/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

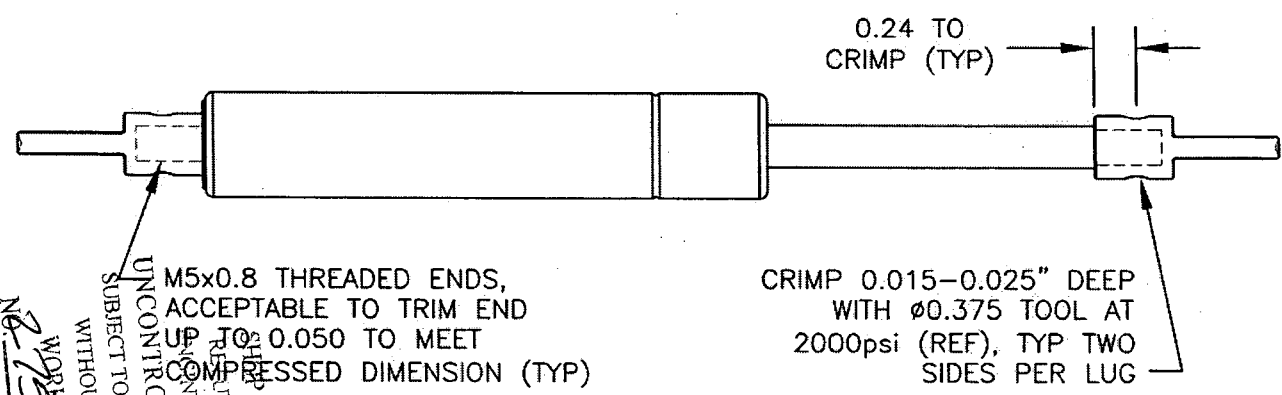
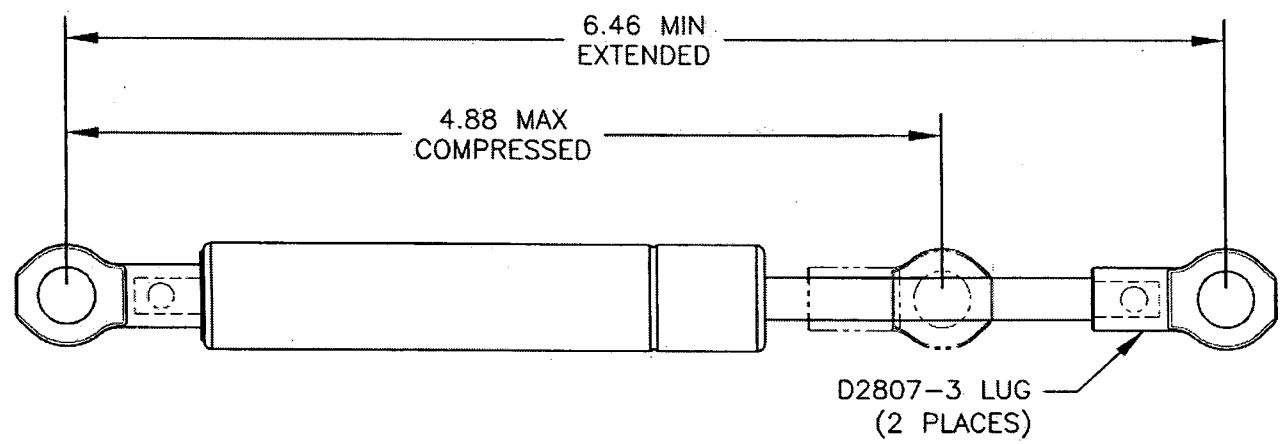
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



RELEASED  
# 05.06.16

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.25	TITLE	D2807	REV. C
			GAS SPRING	SHEET 1 OF 2
A	00.11.03	NEW ISSUE		SCALE 1:1
B	05.03.16	ADD FINISH		
C	05.05.25	CHANGE SPRING TO SS, ADD -3 LUG		



M5x0.8 THREADED ENDS,  
ACCEPTABLE TO TRIM END  
UP TO 0.050 TO MEET  
COMPRESSED DIMENSION (TYP)

UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 27563

**D2807 GAS SPRING**

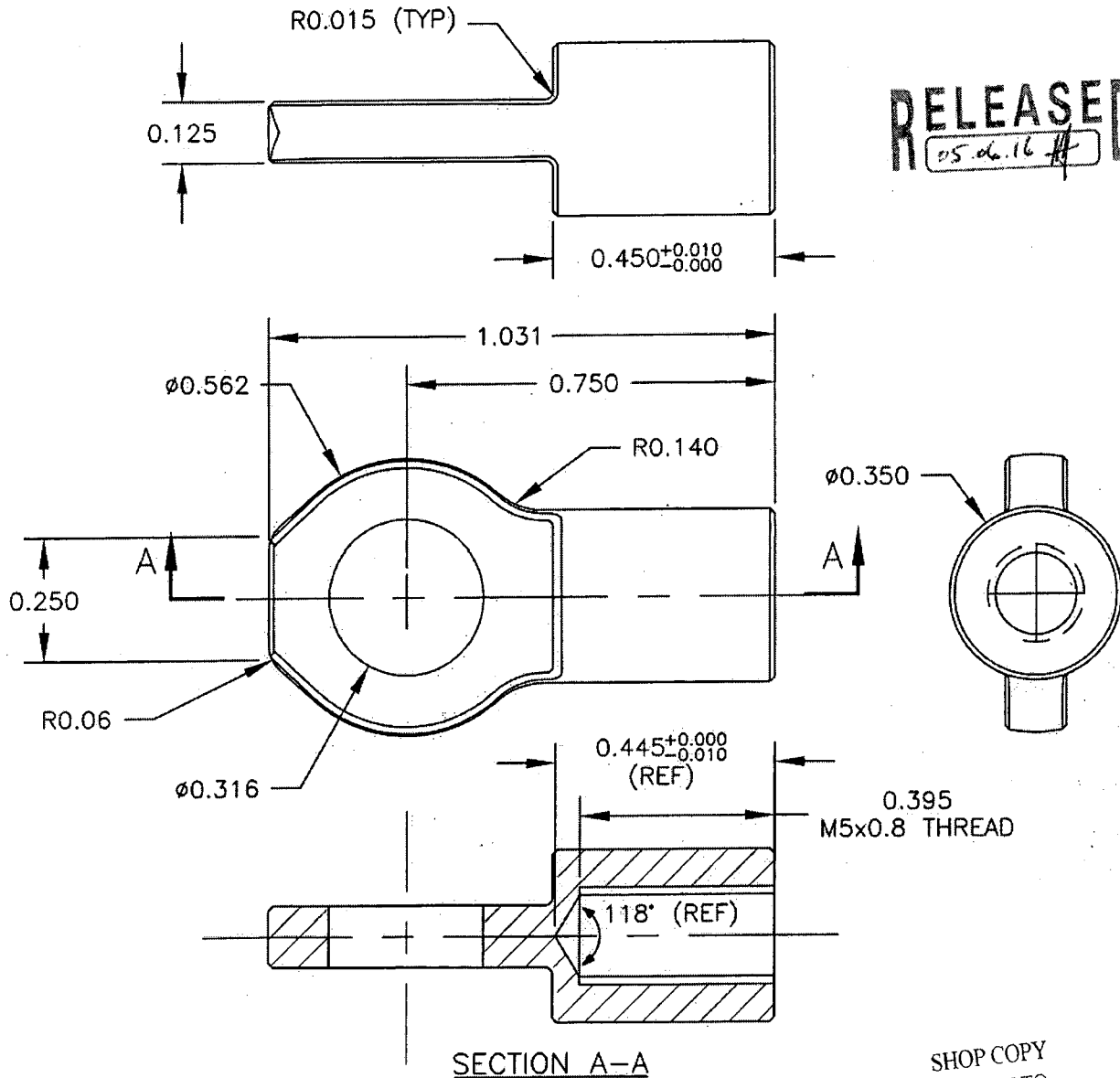
- 1) SPECIFICATION: SS GAS SPRING  
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX  
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK  
P/N: SXF6S6050080S6L-115N  
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25		TITLE GAS SPRING	SCALE 3:1

**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27563

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DART AEROSPACE LTD	Work Order:	27563
Description: Lvs	Part Number:	D 2807-3
Inspection Dwg: 00807, Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

**X**

## First Article

**x**

## Prototype

[illegible]

Measured by: <u>BG/J.F.</u>	Audited by: <u>J.G.</u>	Prototype Approval: <u>N/A</u>
Date: <u>06.07.20</u>	Date: <u>06/07/31</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	